FIG. 1

Table 1

Ex. No. Components	Comp.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%
Rosin (KE604) [a]	40	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
TPNB [b]	54	54	54	54	54	54	54	54	54	54	54	54	54	54	54	58	39	58	39
Styrene dibromide	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
Thixatrol + [c]	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
Isocarb 24 [d]		5												2.5	4	1	20		
Isocarb 36 [e]			5																
Isocarb ester 1605 [f]				5										2.5	1			1	20
Kristol T60 [g]					5														
Paracera MW [h]						5													
Iso stearic acid							5												
Stearic acid								5											
Palmitic acid									5										
Micronised PTPE [i]										5									
200/100cS [j]											5								
Dow Corning 704 [k]												5							
Isofol 24 [l]													5						

[a] Rosin (KE604) available from Arakawa is an acid modified hydrogenated rosin. [b] TPNB available from DOW is tri(propylene glycol) butyl ether.
[c] Thixatrol + available from Rheox is a rheological additive. [d] Isocarb 24 available from Condea is 2-decyltetradecanoic acid.
[e] Isocarb 36 available from Condea is 2-hexadecyleicosanoic.
[f] Isocarb ester 1605 available from Condea is 2-hexyldecanoic acid-pentaerythritol ester.
[g] Kristol T60 available from Carless is mineral oil. [h] Panacera MW available from Industrial Waxes Ltd is paraffin wax.
[i] Micronised PTPE available from Ranic Ltd is PTFE micropowder. [j] 200/100cS available from Dow Corning is polydimethylsiloxane
[k] Dow Corning 704 available from Dow Corning is Tetramethyltetra-phenyltrisiloxane and pentaphenyltri-methltrisiloxane
[l] Isofol 24 available from Condea is 2-decyltetradecanol.

FIG. 2

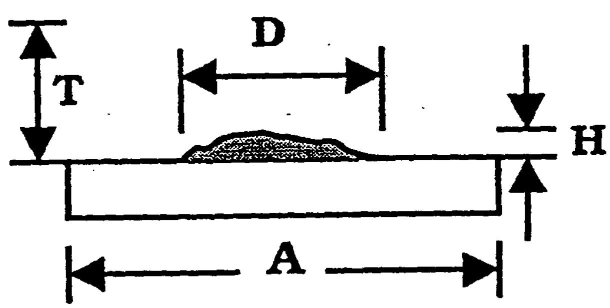

FIG. 3

Table 2

SCORE	DESCRIPTION	VALUES
1	No paste or almost no paste	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
2	More than ½ of pad area covered but insufficient height	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
3	More than ⅔ pad area covered, paste reaches same height as stencil	$D < \frac{2}{3}A$ $H = T$ for $< \frac{1}{3}A$
4	More than ⅔ pad area covered and diameter of top is > ⅓ of aperture	$D < \frac{2}{3}A$ $H = T$ for $< \frac{1}{2}A$
5	Perfect deposit, same shape as stencil aperture	$D = A$ $H = T$ for $> \frac{2}{3}A$

FIG. 4

TABLE 3

Example	Additive (%)	Score
Comparative	None	2
1	Isocarb 24	3
2	Isocarb 36	5
3	Isocarb ester 1605	4
4	Kristol T60	4
5	Pancera MW	4
6	Iso stearic acid	4
7	Stearic acid	3
8	Palmitic acid	4
9	Micronised PTFE	3
10	200/100cS	3
11	Dow Corning 704	3
12	Isofol 24	4
13	Isocarb 24 (2.5) / Isocarb ester 1605 (2.5)	4
14	Isocarb 24 (4) / Isocarb ester 1605 (1)	3
15	Isocarb 24 (1)	3
16	Isocarb 24 (20)	4
17	Isocarb ester 1605 (1)	3
18	Isocarb ester 1605 (20)	3